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881 2 240 000-1A
Job Sheet 185305



Part No: 881 2 240 000-1A

Job Qty: 5 ea

Part Name: Tube Support Bottom Part



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 881 2 240 000 Rev. 5 IPP Rev. A 18.10.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Machining-2		P.J. 18-12-06
110	Mori Seiki	5 pcs	11/23/18	11/23/18	0.00	2.50	MORI NV5000-2		P.J. 18-12-06
120	QC	5 pcs	11/23/18	11/23/18	0.00	0.00	QC2 Machining-4		P.J. 18-12-06
130	QC	5 pcs	11/23/18	11/23/18	0.00	0.00	QC8 Machining-4		P.J. 18-12-06
140	Packaging	5 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1		P.J. 18-12-06
150	QC21-SA	5 Ea	11/23/18	11/23/18	0.00	0.00	QC21		P.J. 18-12-06

Part Op 110 - ***Cut blanks to 2.00**** 1-Machine as per folio FC ? FOLIO REV: ? DWG REV: ?
Descriptions: 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.750X1.750	6061T6 Bar 1.750 X 1.750	.8300 ft (.166 ea)	90-Start up Operation	513/148

Cut 6 pcs

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.750X1.750	1	0	0

Part Specifications

Specifications could not be found.



Container No: S136163



Part: 881 2 240 000-1A

Job No: 185305

Serial No/Batch: S136163

Revision: 5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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www.dartaerospace.com

Date: 12/10/18

Plex 10/24/18 2:59 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

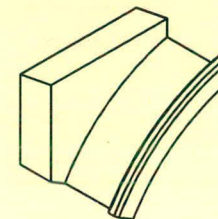
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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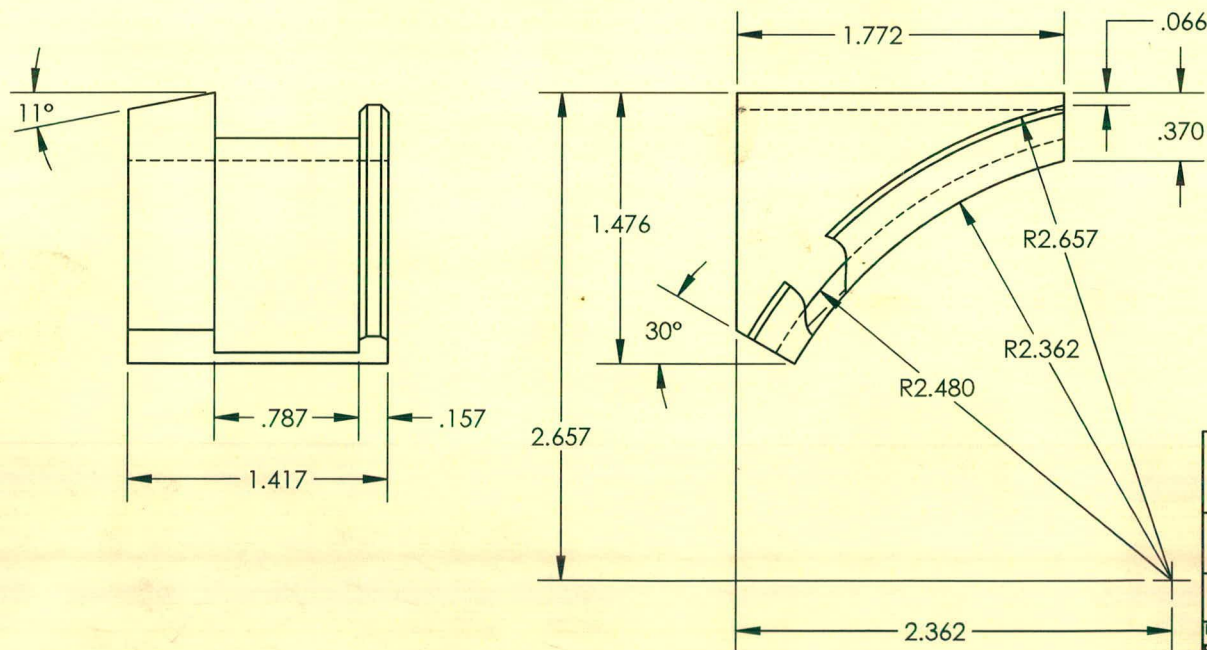
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
C		-1A CH'D FROM 60mm LENGTH TO 45mm, FROM 15° TO 10°.	10/23/2008	WP	RW
D		-1A CH'D INNER STEP RADIUS FROM 65mm TO MATCH TURBOMECA REV'D DRAWING PER GE.	4/20/2012	RJC	GE



2X .04 X 41°



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WORK ORDER
NO. 185305 WCS
181024



(-1A)

TUBE SUPPORT BOTTOM PART

DART AEROSPACE	
TITLE TUBE SUPPORT	
DWG NO. 881 2 240 000-1A	REV 5
MAT'L 6061 FINISH SEE -1 SPEC DRAWN BY: COLE CHECKED: MACKOVJAK OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL ARRIEL SA365 OU 350	
SCALE 1:1	DATE 8/5/2003
SHEET 3 OF 4	

